

Work Order ID: 56792

March 10, 2010 9:55:36 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-3-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

1 *10/3/15*

W/O:		WORK ORDER CHANGES					
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Work Center ID

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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

1 11/03/16

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/03/17



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Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R ☐ ☐ Aluminum Rod

M113207

BE 10/03/23

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R ☐ ☐ Aluminum Rod

M113207

BE 10/03/23

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

BE 10/03/23

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Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8/10/03/23



Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/03/23



f

Quality Control

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

BK 10-3-24

① f

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Hours

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Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

1113170

0.00

=> H

10/03/24

(X) /

Memo

START TIME:

2:45pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

3:15pm

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

BK

10-3-30

0 /

Memo

0.00

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Run Start



QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M113H29

Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ M110429

Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M113H62

BL 10-3-31

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev:

PPD 57238

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



PPPD 57238

10/04/15

MF

10-4-14

56792

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March 10, 2010 9:59:28 AM

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Start Date: 10/03/2010

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2580-1 Manufactured No 110 Each 4.0000 1.0000



205 Skidtube bent detail

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG 4

54541 2

56121 2

D2576-3 Manufactured No 140 Each 130.0000 1.0000



Step (maching detail)

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 130

46661 83

52215 47

1356767 ① M10/3/15

DE 10/03/23

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IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2579 Manufactured No 140 Each 147.0000 20.0000



Crossbolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 25

51525 4

53780 3

54543 18

Main Warehouse

ST 122

43988 4

46434 4

46956 2

47797 9

48272 2

51314 71

51315 30

A

B 56818

** 20*

BE 10/03/23

March 10, 2010 9:59:28 AM

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 142.0000 1.0000



Cap



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST026 142

50513 1

50770 1

51539 ✓ 37

53791 103

1 10-3-31

AN3-5A Purchased No 200 Each 1,405.000 2.0000



Bolt



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST350 1405

100188 188

105057 ✓ 1217

2 10-3-31

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Start Qty: 1.00

Required Qty: 1.00

AN960JD10L

Purchased

No

200

Each

3,105.000 2.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST348

3105

101291

16

105793

49

110985 ✓

3040

ALS7-1032-130

Purchased

No

200

Each

986.0000 50.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST282

986

108606

52

111529

130

111779

34

112772

11

113238 ✓

759

2 BK 10-3-31

50 BK 10-3-31

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 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 1,499.000 50.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST350	1499	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	64	
113226 ✓	344	
113644	12	
113749	48	
114103 ✓	500	
114108	500	

17
 33.
 BR 10-3-31.

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Start Qty: 1.00

Required Qty: 1.00

AN960C10L

Purchased

No

200

Each

388.0000

50.0000



washer

NAS1149C 0322R

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

113691

100

103585

100

Main Warehouse

ST

288

112116

128

112612

160

50, BR 10-3-31.

D3566-13

Manufactured

No

200

Each

72.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

70

53461

70

Main Warehouse

ST

2

45717

1

50265

1

1 BR 10-3-31

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Dart Aerospace Ltd

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IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured No

200

Each

23.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

19

55026

7

55335 ✓

12

Main Warehouse

ST

4

36113

1

46186

1

47318

1

51260

1

BR 10-3-31

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 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 200 Each 33.0000 2.0000
 Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 56825	28
52512	3
54480	1
55011	1
55320	3
56532 ✓	20

Main Warehouse

ST	5
46349	1
51218	1
51259	3

1 BK 10-3-31

1 BK 10-3-31

D3564-11 Manufactured No 200 Each 9.0000 1.0000
 Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19 56834	7
55332	7

Main Warehouse

ST	2
45823	1
50112	1

1 BK 10-3-31

March 10, 2010 9:59:29 AM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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March 10, 2010 9:59:29 AM

Page 9

Work Order ID: 56792



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 10/03/2010

Required Date: 26/03/2010

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

33.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP17

21

56285 ✓

21

Main Warehouse

ST

12

45409

2

46495

10

1 BL 10-3-31.

D3564-9

Manufactured No

200

Each

18.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP19

16

55025 ✓

4

55334 ✓

12

Main Warehouse

ST

2

44659

1

45825

1

1 BL 10-3-31.

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 10, 2010 9:59:29 AM

Work Order ID: 56792



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 10/03/2010

Required Date: 26/03/2010

Comments: IPP Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 HKJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by: DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D3564-5 Manufactured No 200 Each 33.0000 1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	29	
51925	1	
54772	4	
55024 ✓	12	
55333	12	
Main Warehouse		
ST	2	
45824	1	
47433	1	

1 BL 10-3-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 56792



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube


Start Date: 10/03/2010

Required Date: 26/03/2010

Comments: IPP Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by: DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2594-3 Manufactured No 200 Each 500.0000 16.0000

 O-Ring, 205 Skidtube

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	487	
51613	27	
55546 ✓	460	
Main Warehouse		
ST	13	
52562	13	

16. PK 10-3-31.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 12

Work Order ID: 56792



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 10/03/2010

Required Date: 26/03/2010

Comments: IPP Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev P 10.02.19 per PAR09-043 EC verified by: DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev: P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

D2594-1

Manufactured No

200

Each

577.0000

16.0000



Plug, 205 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

449

54008

1

54643

15

55002 ✓

433

Main Warehouse

ST

128

42221

16

42807

92

43884

3

46435

2

51527

9

51757

6

16. 12/103.31

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56792

Bf
10-3-10

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

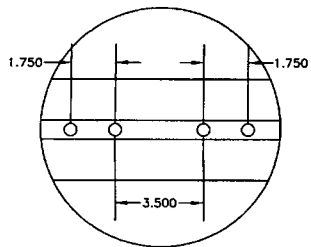
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

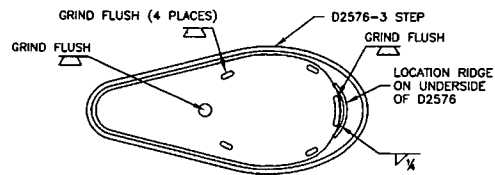
NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

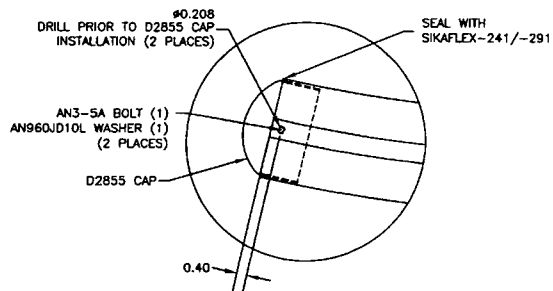


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07-06-28-11

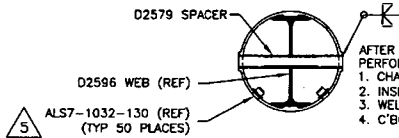
DETAIL B
SCALE 5:24



DETAIL C
SCALE 5:24



SECTION D-D
SCALE 5:24



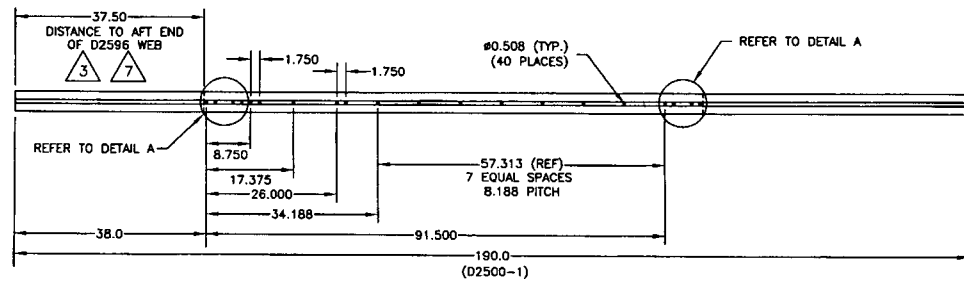
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

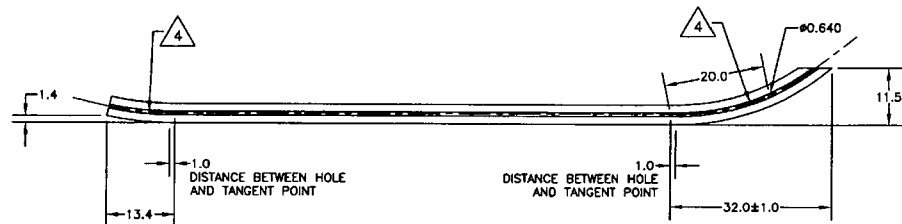
D2580-041 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

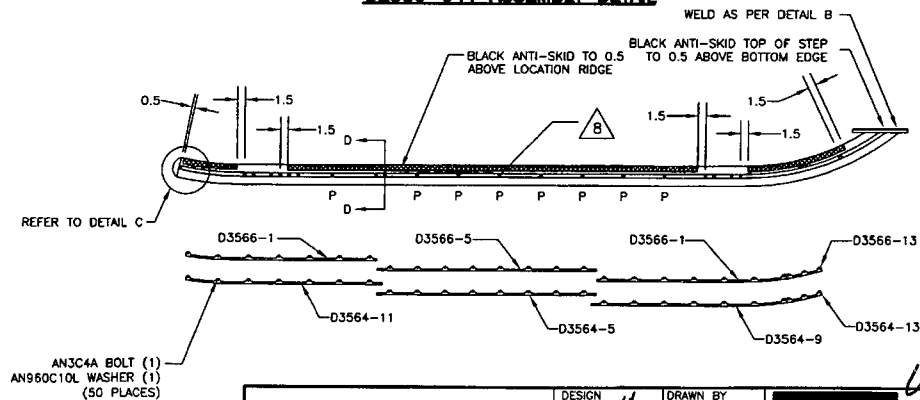
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL





D2580-041 ASSEMBLY DETAIL




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DESIGN	
CHECKED	
DATE	07.02.27

DRAWN BY	PH
APPROVED	H

 DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA	
DRAWING NO. D2580	REV. D SHEET 2 OF 3
TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

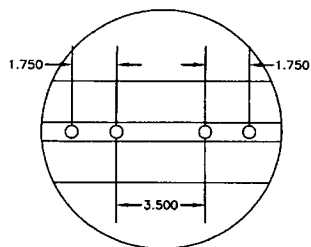
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

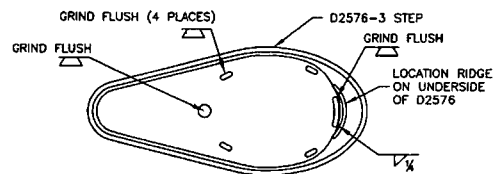
NOTE: Date & initial all entries

DETAIL E
SCALE 5:24

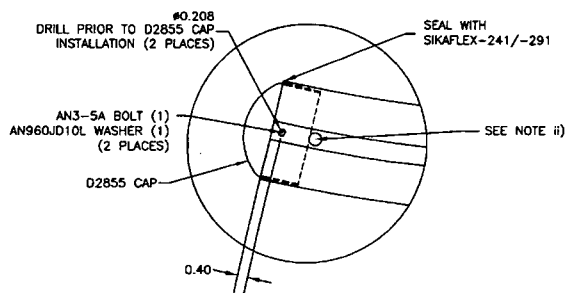


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07.06.78

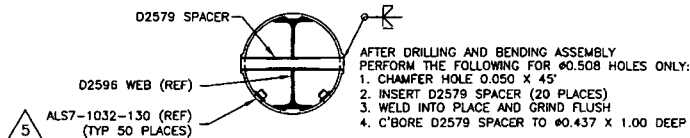
DETAIL F
SCALE 5:24



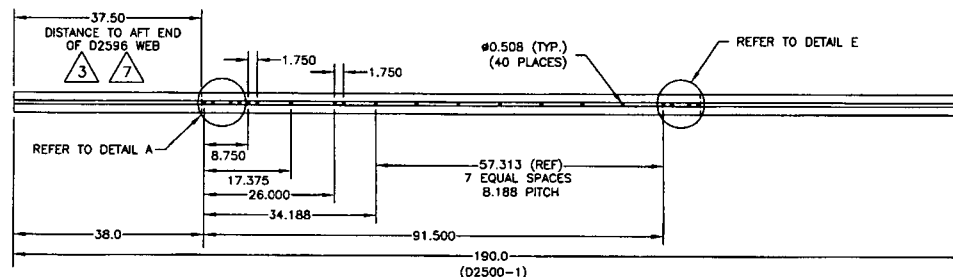
DETAIL G
SCALE 5:24



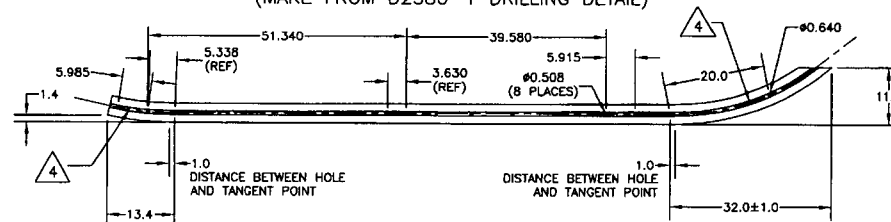
SECTION H-H
SCALE 5:24



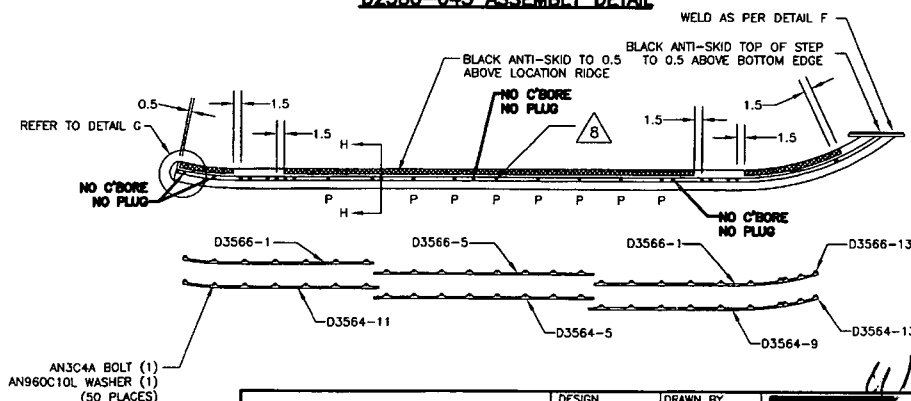
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN RH	DRAWN BY RH	DART DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA	REV. 0
CHECKED H	APPROVED H	DRAWING NO. D2580	SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 227

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 56925
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Smith Date of Test Coupon 0.03.19

Welder Barday Elliott Date of Test Coupon 16-03-19

The above named individual is qualified in accordance with AWS D17.1.2001 to weld